

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026672**Date Inspected:** 08-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Watson Bowman ACME**Location:** Buffalo, NY**CWI Name:** Reno Davis, John Crabtree**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Joint Hinge A**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Reno Davis Day Shift, and Mr. John Crabtree night shift. ABF Representatives are the Quality Control personnel for this location.

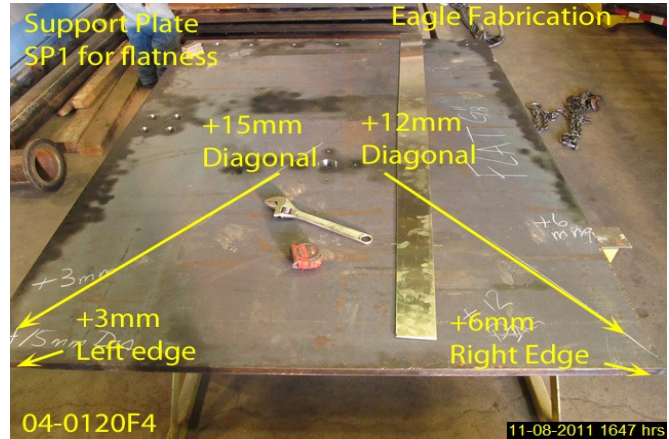
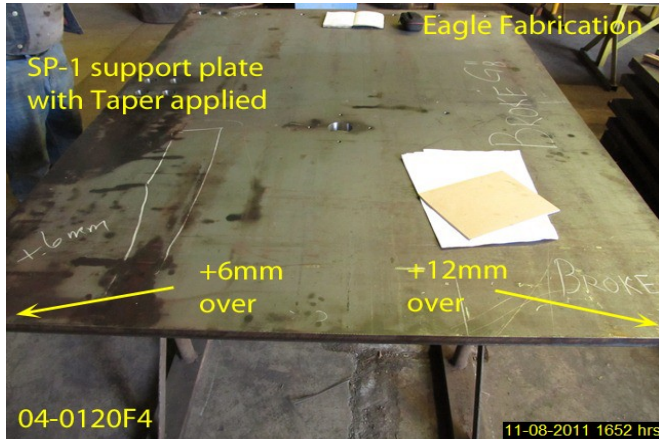
This QAI arrived at WBA and noted that welder Jayson Gray was performing Flux Core Arc Welding (FCAW) welding on component SEI112667-CA2-9, using Hobart (Tri-Mark) TM-811N1 electrode. The weld joint was identified as a Complete Joint Penetration (CJP) welds. The weld numbers were 7D, 7E and 7F. The welder had placed the reinforcing fillet welds (7A, 7B and 7C) and then using a grinder back gouged into the reinforcing fillet to produce the CJP weld. Mr. Gray at the time of the observation was performing the grinding operations. John Crabtree is monitoring the welding for ABF on the night shift were James DiVirgillio is performing welding and fit up of CA2-10.

This QAI arrived at Eagle Fabrication the Sub Contractor for Watson Bowman Acme (WBA) who had performed the 19mm taper last week (Friday 11-4-11) on SP1. This QAI along with Eagle fabrication personnel and WBA QCM Greg Ross was onsite to record plate measurements of 2 plates for flatness and 1 plate that had the 19mm taper applied. During the measurements of the SP1 support plate where the taper was applied the measurement on the left edge was +3mm over and the right hand edge was measured as +12mm over the 19mm taper. For SP1

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measurements for flatness prior to applying the taper the measurements were; Left hand edge +3mm right hand edge +6mm and diagonals were +15mm towards the left hand edge and +12mm towards the right hand edge. Also checked was SP3 for flatness with measured readings of +12mm for the left hand edge and +10mm for the right hand edge. The diagonals were +10mm towards the left hand edge and +16 towards the right hand edge. These measurements were emailed along with the photos to the Structural Materials Representative (SMR) for further review. Mr. Ross of WBA instructed Eagle Fabrication to move forward and flatten one plate to see how flat they could get it prior to taper. Then hold the plate for this QAI and Mr. Ross to be onsite for the taper to be applied for witnessing.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC, and WBA personnel .

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
